

IN THE CLAIMS

Claims 1-22 (Previously Cancelled)

Claim 23 (Previously presented)

A method of forming a fuel container with an opening and a cap sealing the opening, comprising the steps of:

providing a pair of mold halves defining a first mold cavity to form and define the shape of a container from a parison by blow molding and adjacent the first cavity a second cavity to form at least one cap in a flash section from the parison by compression molding;

providing a parison with a hydrocarbon fuel vapor barrier layer of a polymeric material disposed between inner and outer layers of a different polymeric material which is heat weldable;

closing the mold halves together to receive and compress a portion of the parison between them forming at least one flash section in the region of the second cavity and at least one cap in the second cavity in the flash section by compression molding;

providing a pressurizing fluid into the parison within the closed mold halves to expand the parison within the first mold cavity to form the entire container and define the shape of the container by blow molding;

forming an opening through the container at a location spaced from the cap;

before filling the container, separating the cap from the flash section;

before filling the container, disposing the cap over the opening; and

before filling the container, heat welding the cap to the container circumferentially continuously to permanently attach and seal the cap to the container to permanently close, seal and provide a fuel vapor barrier for the opening.

Claim 24 (Cancelled)

Claim 25 (Previously presented)

The method of claim 23 wherein the parison, container and cap have multiple layers of polymeric material including at least one structural layer and at least one vapor barrier layer.

Claim 26 (Previously presented)

The method of claim 23 which also comprises heat welding at least one of the inner layer and the outer layer of the cap to the outer layer of the container to permanently attach and seal the cap to the container.

Claim 27 (Cancelled)

Claim 28 (Previously presented)

The method of claim 23 which further comprises simultaneously extruding the fuel vapor layer and the inner and outer layers into the parison which is received in a generally molten state between the open mold halves in a blow molding machine to form the container and cap.

Claim 29 (Previously presented)

The method of claim 23 wherein the cap has twice as many vapor barrier layers as the vapor barrier layer(s) of the container.

Claim 30 (Previously presented)

The method of claim 28 wherein the inner layer and the outer layer of the parison, container and cap are of a high density polyethylene polymer material.

Claim 31 (Previously presented)

The method of claim 30 wherein layers of high density polyethylene polymer material of the container and the cap are heat welded together to permanently attach and seal the cap to the container.

Claim 32 (Previously presented)

A method of forming a fuel container with an opening and a cap sealing the opening, comprising the steps of:

providing a pair of mold halves defining a first mold cavity to form and define the shape of a container by blow molding and adjacent the first cavity a second cavity to form at least one cap in a flash section by compression molding;

providing a parison with at least one hydrocarbon fuel vapor barrier layer of a polymeric material disposed between inner and outer layers of a different polymeric material which is heat weldable;

closing the mold halves together to receive and compress in the second cavity two overlapping portions of the parison between them forming at least one flash section in the

region of the second cavity and at least one cap in the flash section by compression molding with the cap having twice as many vapor barrier layers as the vapor barrier layer(s) of the container and two adjacent inner layers of the different polymeric material adhered together;

providing a pressurizing fluid into the parison within the closed mold halves to expand the parison within the first mold cavity to form the entire container and define the shape of the container by flow molding;

forming an opening through the container at a location spaced from the cap;

before filling the container, separating the cap from the flash section;

before filling the container, disposing the cap over the opening; and

before filling the container, heat welding the cap to the container circumferentially continuously to permanently attach and seal the cap to the container to permanently close, seal and provide a fuel vapor barrier for the opening.

Claim 33 (Previously presented)

The method of claim 32 which also comprises heat welding at least one of the inner layer and the outer layer of the cap to the outer layer of the container to permanently attach and seal the cap to the container.

Claim 34 (Previously presented)

The method of claim 32 which further comprises simultaneously extruding the at least one fuel vapor layer and the inner and outer layers into the parison which is received

in a generally molten state between the open mold in a blow molding machine to form the container and cap.

Claim 35 (Previously presented)

The method of claim 32 wherein the inner layer and the outer layer of the parison, container and cap are of a high density polyethylene polymer material.

Claim 36 (Previously presented)

The method of claim 35 wherein the layers of high density polyethylene polymer material of the container and the cap are heat welded together to permanently attach and seal the cap to the container.

Claim 37 (New)

A method of forming a fuel container with an opening and a cap sealing the opening, comprising the steps of:

providing a pair of mold halves defining a first mold cavity to form and define the shape of a container from a parison by blow molding and adjacent the first cavity a second cavity to form at least one cap in a flash section from the parison by compression molding;

providing a parison with a hydrocarbon fuel vapor barrier layer of a polymeric material disposed between inner and outer layers of a different polymeric material which is heat weldable;

closing the mold halves together to receive and compress a portion of the parison between them forming at least one flash section in the region of the second cavity and at least one cap in the second cavity in the flash section by compression molding;

providing a pressurizing fluid into the parison within the closed mold halves to expand the parison within the first mold cavity to form the entire container and define the shape of the container by blow molding;

forming an opening through the container at a location spaced from the cap;

separating the cap from the flash section;

disposing the cap over the opening; and

heat welding the cap to the container circumferentially continuously to permanently attach and seal the cap to the container to permanently close, seal and provide a fuel vapor barrier for the opening.

Claim 38 (New)

A method of forming a fuel container with an opening and a cap sealing the opening, comprising the steps of:

providing a pair of mold halves defining a first mold cavity to form and define the shape of a container by blow molding and adjacent the first cavity a second cavity to form at least one cap in a flash section by compression molding;

providing a parison with at least one hydrocarbon fuel vapor barrier layer of a polymeric material disposed between inner and outer layers of a different polymeric material which is heat weldable;

closing the mold halves together to receive and compress in the second cavity two overlapping portions of the parison between them forming at least one flash section in the

region of the second cavity and at least one cap in the flash section by compression molding with the cap having twice as many vapor barrier layers as the vapor barrier layer(s) of the container and two adjacent inner layers of the different polymeric material adhered together;

providing a pressurizing fluid into the parison within the closed mold halves to expand the parison within the first mold cavity to form the entire container and define the shape of the container by flow molding;

forming an opening through the container at a location spaced from the cap;

separating the cap from the flash section;

disposing the cap over the opening; and

heat welding the cap to the container circumferentially continuously to permanently attach and seal the cap to the container to permanently close, seal and provide a fuel vapor barrier for the opening.